

Work Order ID 134866

Wednesday, July 22, 2015 4:14:12 PM

134866

Page 1

Item ID: D3942-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clip
 Start Date: 7/19/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/22/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUL 23 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3942	C								

100 0.00

100

Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3942-3

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

(20)

02/15/08/13

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC
Quality Control

Memo

0.00

(20)

02/15/08/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																								
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Work Order ID 134866

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134866

Page 2

Item ID: D3942-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 7/19/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/22/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp
DAS
38
9-89

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(20)

AUG 13 2015

140

Identify as per dwg & Stock Location: ST068

0.00

140

Packaging

Memo

0.00

Packaging

DAS
28
9-89

(20)

JA

AUG 14 2015

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCS

AUG 14 2015

MCS

AUG 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, July 22, 2015 4:14:12 PM

Page 1

Work Order ID: 134866

134866

Parent Item: D3942-3

D3942-3

Parent Item Name: Clip

Start Date: 7/19/15

Required Date: 7/22/15

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A UPDATE TO REV B 10-11-24 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased			No	100	sf	296.5776	0.015	0.157895			

M304S18GA

304/316 .050 Sheet

06/15/08/13

Location

Loc Qty

Loc Code

MAT020

208.6276

M128254

5.1887

M128435

25

M128864

31.5964

M129530

34.3667

M130923

28.0424

M131384

20.4334

M132797

64

MAT20

87.95

M131700

87.95

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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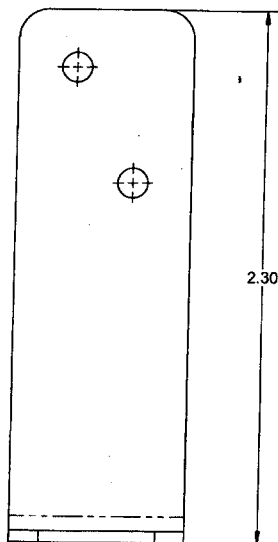
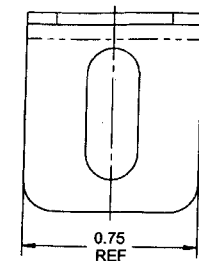
DART AEROSPACE LTD		Work Order:	134866
Description: Clip		Part Number:	D3942-3
Inspection Dwg: D3942 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø.128	/		V: D-02	
0.75	+/-0.030	.753	/			
0.25	+/-0.030	.249	/			
0.25	+/-0.030	.248	/			
0.75	+/-0.030	.749	/			
0.38	+/-0.030	.374	/			
0.34	+/-0.030	.311	/			
2.50	+/-0.030	2.497	/			
0.050	+/-0.010	.048	/			
Ø.275	-.001 +.006	Ø.274	/			

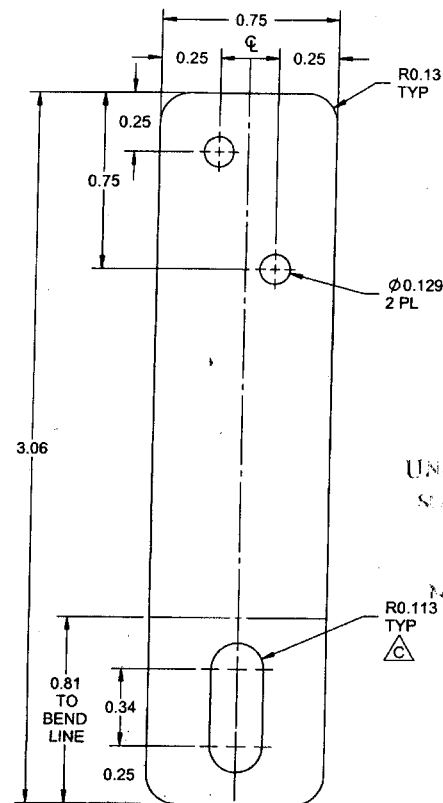
Measured by:	DL	Audited by:	DAS 38 9-88	Preliminary Approval:	
Date:	15/08/13	Date:	AUG 13 2015	Date:	

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	
B	11.01.17	Dimensions update per Dwg Rev B	KJ	
C	13.02.27	Dimensions update per Dwg Rev C	KJ	



D3942-1 ANGLE
MADE FROM D3942-1F

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524 18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.03 lbs



D3942-1F FLAT PATTERN

REV.	DESCRIPTION	BY	DATE
C	INCREASE SLOT/HOLE SIZE TO ALLOW PROPER FITTING OF PANEL: 0.113 WAS 0.094, ZN B2-1; 0.275 WAS 0.257, ZN C5-2 (REF PAR 10-008)	XDF	11.09.02
B	REVISE LENGTH OF 3 PART, ZN C3-2: UPDATE IDENTIFICATION, ZN A7-1, A7-2	HS	10.11.19
A	NEW ISSUE	HS	09.05.06
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.09.02		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3942	REV. C SHEET 1 OF 2
TITLE BRACKET	SCALE NTS
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RELEASED
2011-12-12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3942	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11:09:02	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	